

Work Order ID 79555

January-27-12 12:51:11 PM

79555

Page 1

Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly Aft, Low Gear
 Start Date: 27/01/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3805	B

100 0.00

100

Large Fab

Large Fab

Memo

0.00

1-weld D3806-5 to D3805-5 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M120013

Sadel 2059B → M122279

2-Transfer drill holes in bar

(X10)

MAL

12/07/24

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

10

12.7.24

DAS
24
20

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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 27/01/2012 **Start Qty:** 8.00 ***8***

Cust Item ID:

Required Date: 10/02/2012 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

120

QC

Memo

0.00

Quality Control

0.00

130

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

140

OC

Quality Control

Memo

0.00

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Picklist Print

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Parent Item: D3805-045

D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3805-5		Manufactured	No			100	Each	65.0000	1	8			
D3805-5									**	(X10)	MAL	12/07/24	
Plate													

B 79568 (X10)

Location	Loc Qty	Loc Code
WA030	65	
75676	2	
78128	60	
78811	3	

D3806-5		Manufactured	No			100	Each	14.0000	1	8			
D3806-5									**	(X10)	MAL	12/07/24	
Bar													

B 79570 (X10)

Location	Loc Qty	Loc Code
WA	10	
74889	10	
WA030	4	
46781	2	
75941	2	

D3807-5		Manufactured	No			150	Each	64.0000	1	8			
D3807-5									**	B 79626 → (7)			
Gasket										B 79572 → (3)			

Location	Loc Qty	Loc Code
GA	64	
74944	1	
76742	1	
78132	62	

Ac 12.07.25

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B	REVISED D808-1F/3F TO EASE MANUFACTURABILITY (AMOUNT CUTOUT AT FIVE/6 OF PLATE PER PART11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3		MB	11.09.16
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE USA, INC.		
DRAWN		KENT, WA		
CHECKED		DRAWING NO.	REV. F	
MFG. APPR.		D3805	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		WEARPLATE ASSY	NTS	
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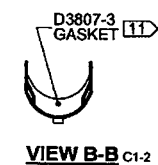
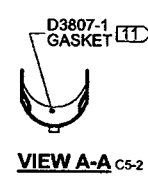
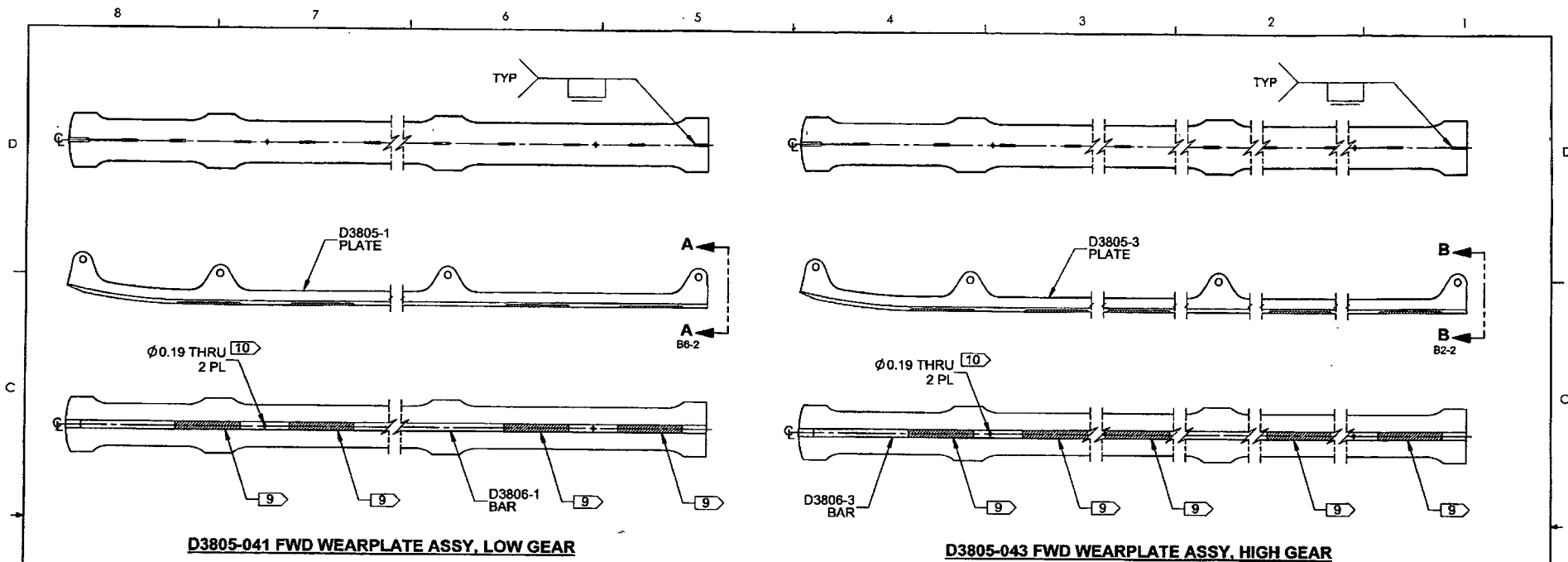
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2011-10-03

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2053B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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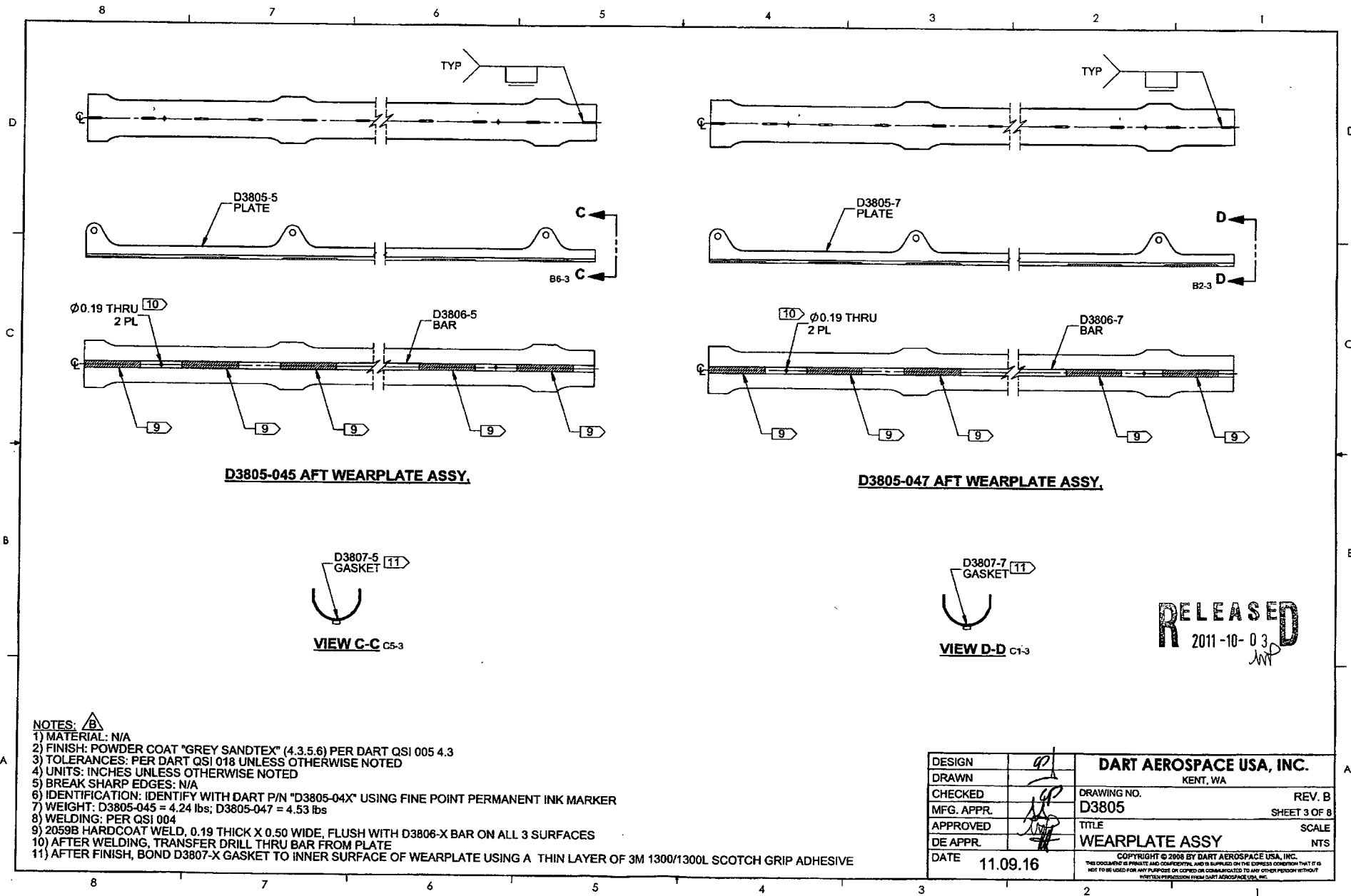
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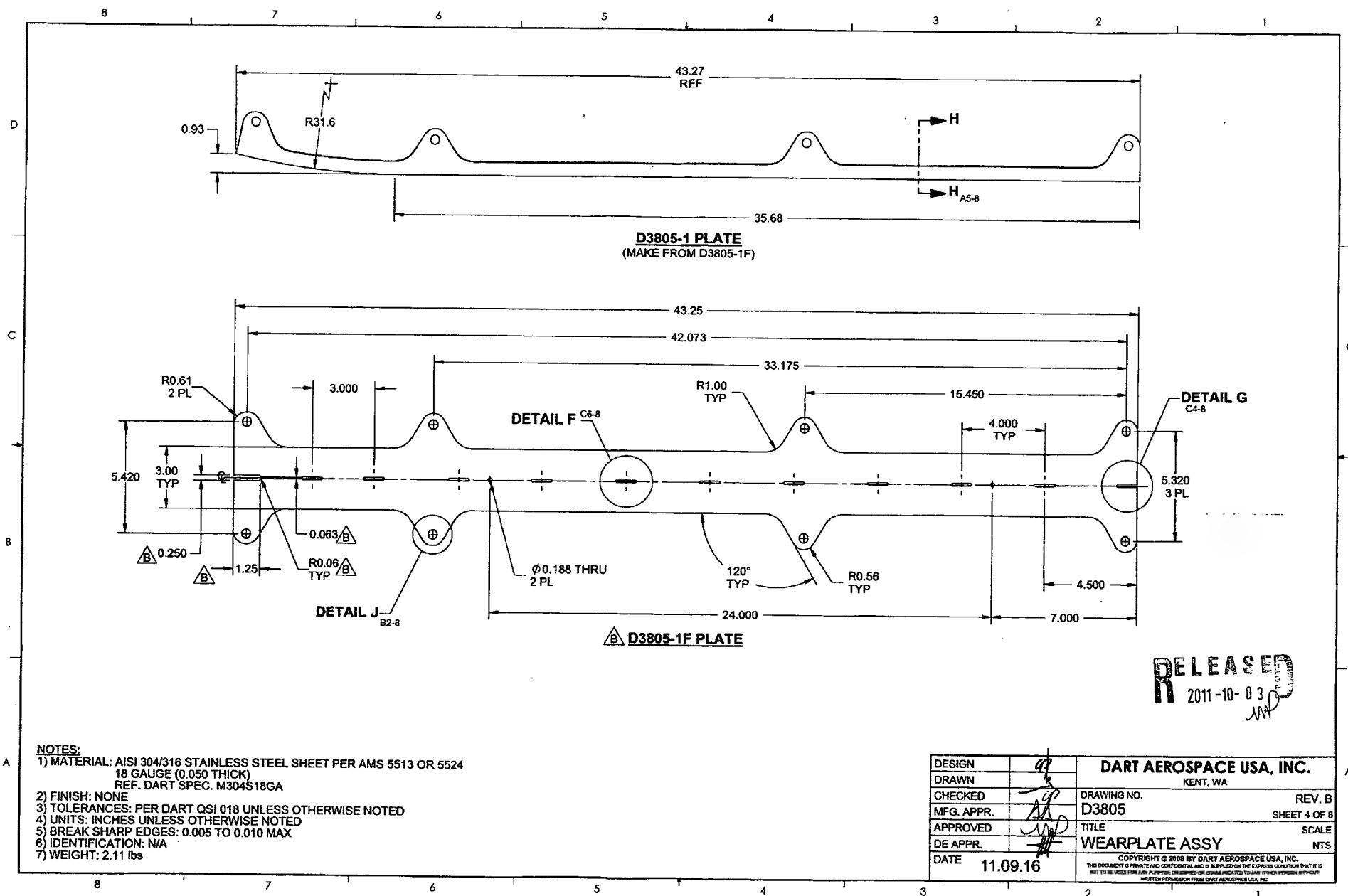
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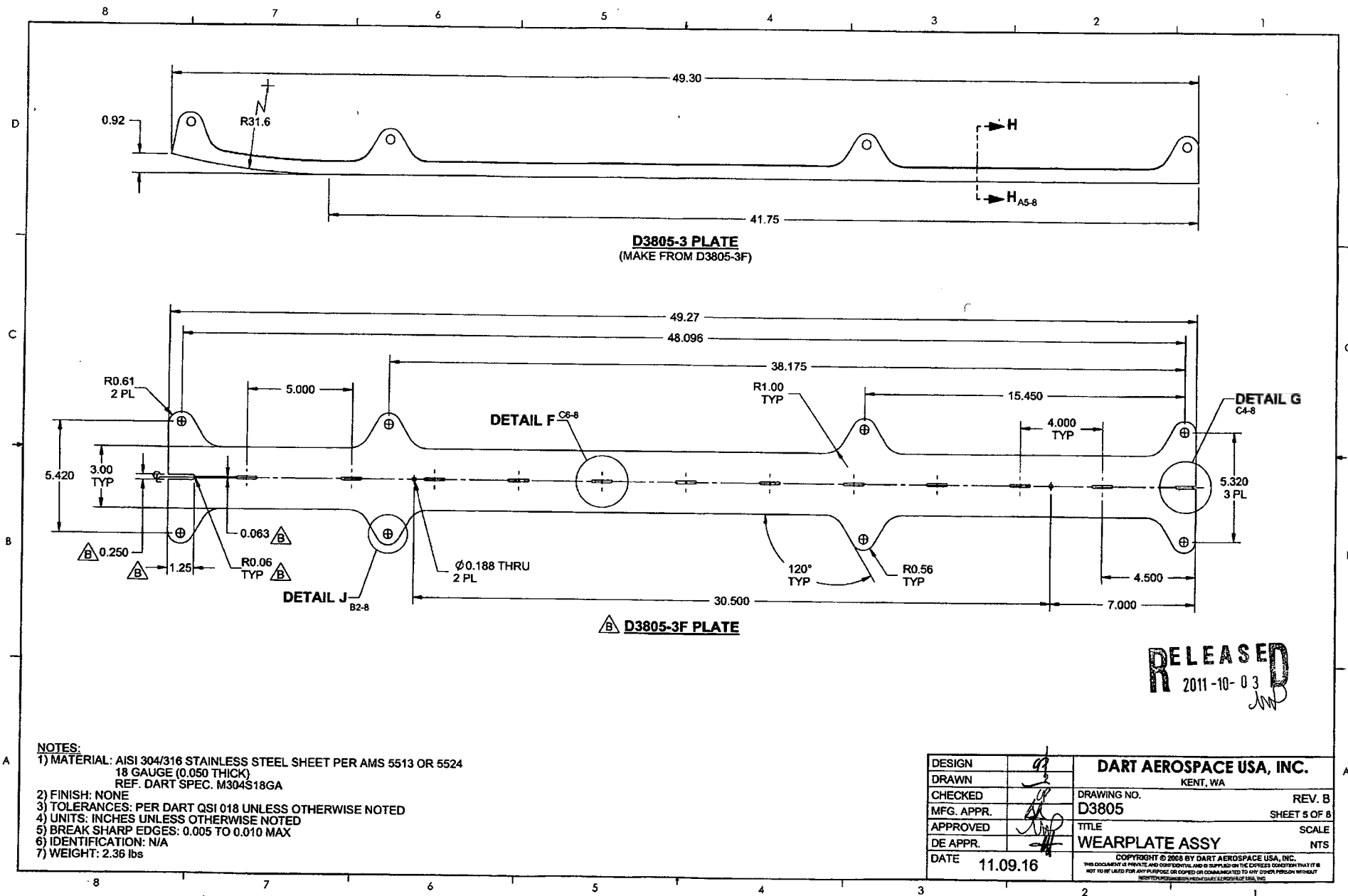
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39.425 3.515



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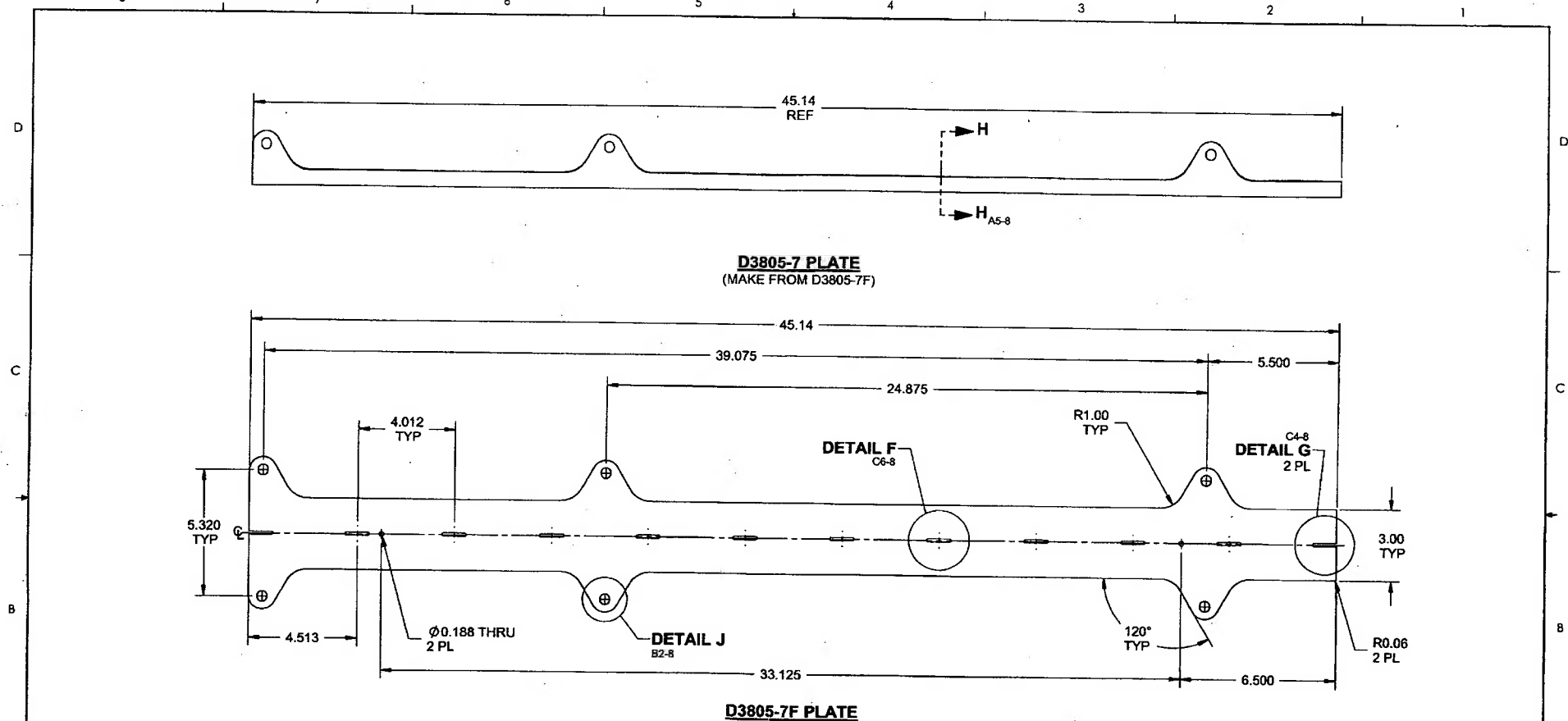
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2011-10-03
ND

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

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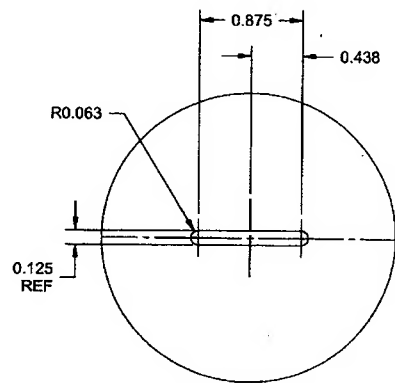
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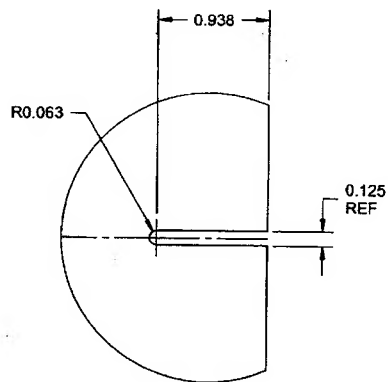
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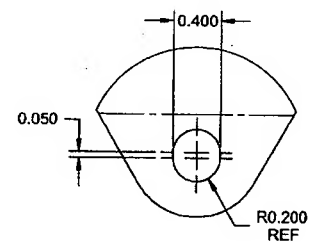
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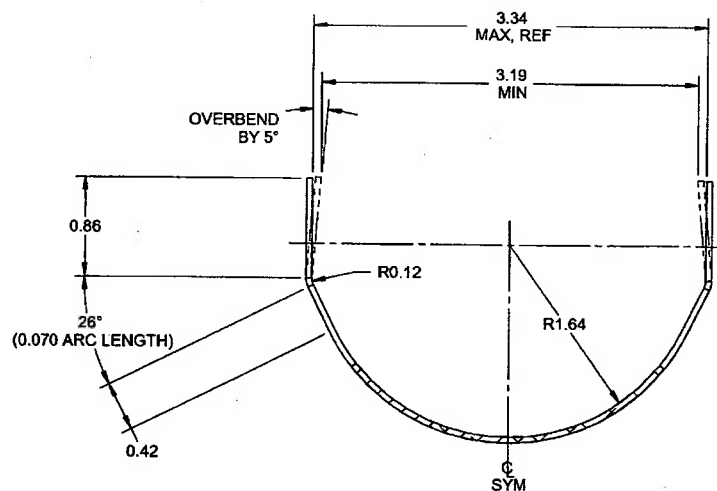
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SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7




DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

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